

Split

Work Order ID 150637-1

150637

Page 1

Monday, August 29, 2016 2:52:03 PM

Item ID: 646.3301 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Upper Cutter Assy
Start Date: 8/3/2016 Start Qty: 5.00 *5* Cust Item ID:
Required Date: 8/29/2016 Req'd Qty: 5.00 *5* Customer:
Reference:

Approvals: Process Plan: DAS 21 9-89 Date: AUG 30 2016 Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
646.3300	NC3

110 Pick Kit 0.00

110

Packaging

Memo

0.07

Packaging

SEP 20 2016

5

DAS
6
9-89

120

0.00

120

Small Fab

Memo

0.50

Small Fab

TWO fastener must be install finger-tight (see note 9)

Assemble as per dwg and apply loctite 598 on all faying surfaces shown on dwg per note 7.

A/R RTV LOCTITE 598: 135479
exp. date: 01/18

IX

16/10/11

DAS
36
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Description Work Order Deviation				Disposition																																																													
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

Work Order ID 150637

Monday, August 29, 2016 2:52:03 PM

150637

Page 2

Item ID: 646.3301

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Upper Cutter Assy

Start Date: 8/3/2016 Start Qty: 5.00

5

Cust Item ID:

Required Date: 8/29/2016 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC5- Inspect part completeness to step on W/O	0.00							
130									
QC	Memo	0.07							DAS 38 9-89 OCT 11 2016
Quality Control									
140	Identify as per dwg & Stock Location: <u>CEK016</u>	0.00							
140									
Packaging	Memo	0.02							DAS 6 9-89 OCT 11 2016
Packaging	***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND REV***								
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.01							DAS 21 9-89 OCT 13 2016
Quality Control									

DAS
21
9-89

OCT 11 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																		
Description Work Order Deviation				Disposition																					

Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____					
Misidentified ☐	Past Due ☐						

Picklist Print

Monday, August 29, 2016 2:52:02 PM

Page 1

Work Order ID: 150637

150637

Parent Item: 646.3301

646.3301

Parent Item Name: Upper Cutter Assy

Start Date: 8/3/2016

Required Date: 8/29/2016

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP REV:A 12.10.19 NEW ISSUE DD VERF:JLM
REV:B 15.01.07 AS PER DWG NC3 DD VERF:JLM

IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
646.3310 *646.3310* LH Half - Upper Cutter Assembly		Manufactured	No			110	Each	10.0000	1	5			DAS 6 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				CCK022				10					
				142474				1					
				148318				9					
646.3311 *646.3311* RH Half - Upper Cutter Assembly		Manufactured	No			110	Each	8.0000	1	5			DAS 6 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				CCK022				8					
				142624				8					
646.3312 *646.3312* Center Plate		Manufactured	No			110	Each	10.0000	1	5			DAS 6 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				cck103				10					
				148334				10					
646.3313 *646.3313* Upper Guide		Manufactured	No			110	Each	12.0000	1	5			DAS 6 9-89 SEP 20 2016
				<u>Location</u>				<u>Loc Qty</u>					
				cck059A				12					
				141020				12					

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																	
OTHER : _____																									

Picklist Print

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Work Order ID: 150637

150637

Parent Item: 646.3301

646.3301

Parent Item Name: Upper Cutter Assy

Start Date: 8/3/2016

Required Date: 8/29/2016

Start Qty: 5.00

Required Qty: 5.00

646.3314 Manufactured No

110

Each

8.0000

1

5

646.3314

Blade

DAS
6
9-89

Location

Loc Qty

Loc Code

cck103

8

148327

8

646.3315

Manufactured No

110

Each

8.0000

1

5

646.3315

Blade

DAS
6
9-89

Location

Loc Qty

Loc Code

cck103

8

148321

8

646.3316

Manufactured No

110

Each

9.0000

1

5

646.3316

Blade

DAS
6
9-89

Location

Loc Qty

Loc Code

cck103

9

142636

1

148271

8

NAS1149FN832P

Purchased

No

110

Each

1,732.000

36

180

NAS1149FN832P

Washer

135603

DAS
6
9-89

Location

Loc Qty

Loc Code

GA

1553

M133316

16

M133769

89

M135058

1448

ST263

179

M134257

179

SEP 2 n 7m16

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Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐						
Date :		Step #:		QTY Effective :		MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				
								Completed By
								Lead hand / Supervisor Approval Verification
								QC / QA Coordinator Approval
Root Cause		FAULT CATEGORY						
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : ☐		

Picklist Print

Monday, August 29, 2016 2:52:03 PM

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Work Order ID: 150637

150637

Parent Item: 646.3301

646 3301

Parent Item Name: Upper Cutter Assy

Start Date: 8/3/2016

Required Date: 8/29/2016

Start Qty: 5.00

Required Qty: 5.00

MS21042L08

Purchased

No

110

Each

668.0000

18

90

MS21042L 08

Nut

DAS
6
9-89

Location

Loc Qty

Loc Code

GA

155

m134063

55

m135274

100

ST303

513

m135133

88

m135408

125

m135466

300

90

NAS1149F0332P

Purchased

No

110

Each

1,365.000

6

30

NAS1149F0332P

Washer

DAS
6
9-89

Location

Loc Qty

Loc Code

GA

282

m133709

282

ST262

1083

m135058

1083

30

AN3-12A

Purchased

No

110

Each

32.0000

2

10

AN3-12A

Bolt

DAS
6
9-89

Location

Loc Qty

Loc Code

ST349

32

m133064

16

m134257

16

SEP 2 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Picklist Print

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Page 4

Work Order ID: 150637

150637

Parent Item: 646.3301

646.3301

Parent Item Name: Upper Cutter Assy

Start Date: 8/3/2016

Required Date: 8/29/2016

Start Qty: 5.00

Required Qty: 5.00

MS21042L3

Purchased

No

110

Each

1,509.000

3

15

MS21042L3

DAS
6
9-89

Nut

Location

Loc Qty

Loc Code

FP001

14

m133790

14

GA

323

m134360

112

m135135

211

ST303

1172

m135135

572

m135407

600

MS27039-08-19

Purchased

No

110

Each

70.0000

18

90

MS27039-08-19

DAS
6
9-89

Screw

Location

Loc Qty

Loc Code

GA

1

m135046

1

ST277

69

m135408

69

AN3-14A

Purchased

No

110

Each

86.0000

1

5

AN3-14A

DAS
6
9-89

Bolt

Location

Loc Qty

Loc Code

over003

50

m135056

50

ST349

36

m134360

6

m134852

30

SEP 20 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
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Handling/Pre ☐	☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Material ☐	☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐			
Internal Transport ☐	☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐			
Tribal Knowledge ☐	☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐			
LOA ☐	☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐			
Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER :						
Misidentified ☐	☐	Past Due ☐							

APICAL

INDUSTRIES, INC.

ENGINEERING CHANGE NOTICE NO.

04765

SHEET 1 OF 1

DWG NO. 646.3300

REV: NC

PREPARED BY J. SOTO

DATE: 12/08/2014

EFFECT ON DWG
☐ INC. ☒ UNINC.

DWG TITLE: UPPER CUTTER ASSY

APPROVED BY: ENGR. *[Signature]*

MFG. *[Signature]*

QC *[Signature]*

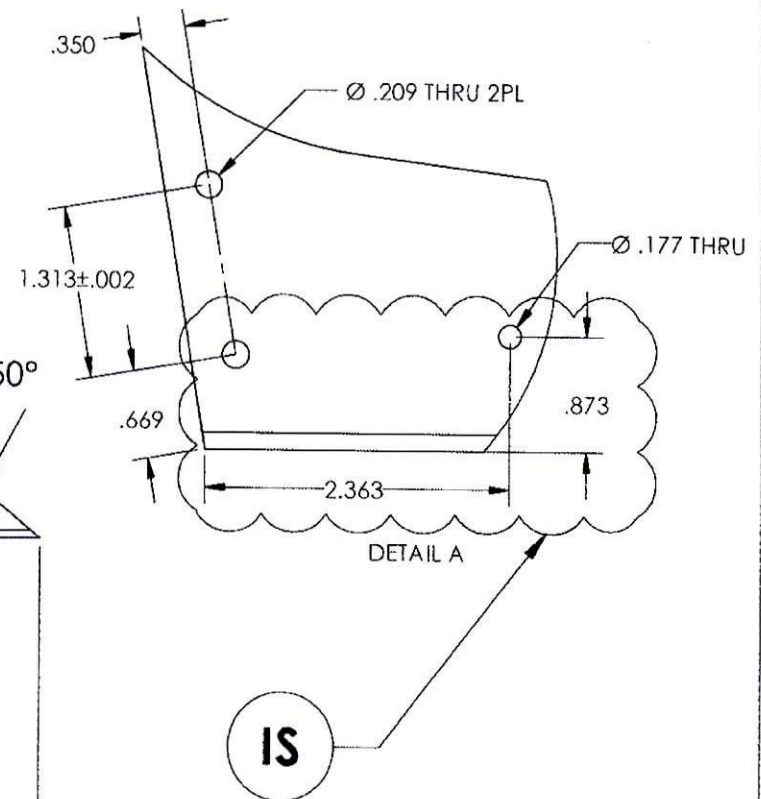
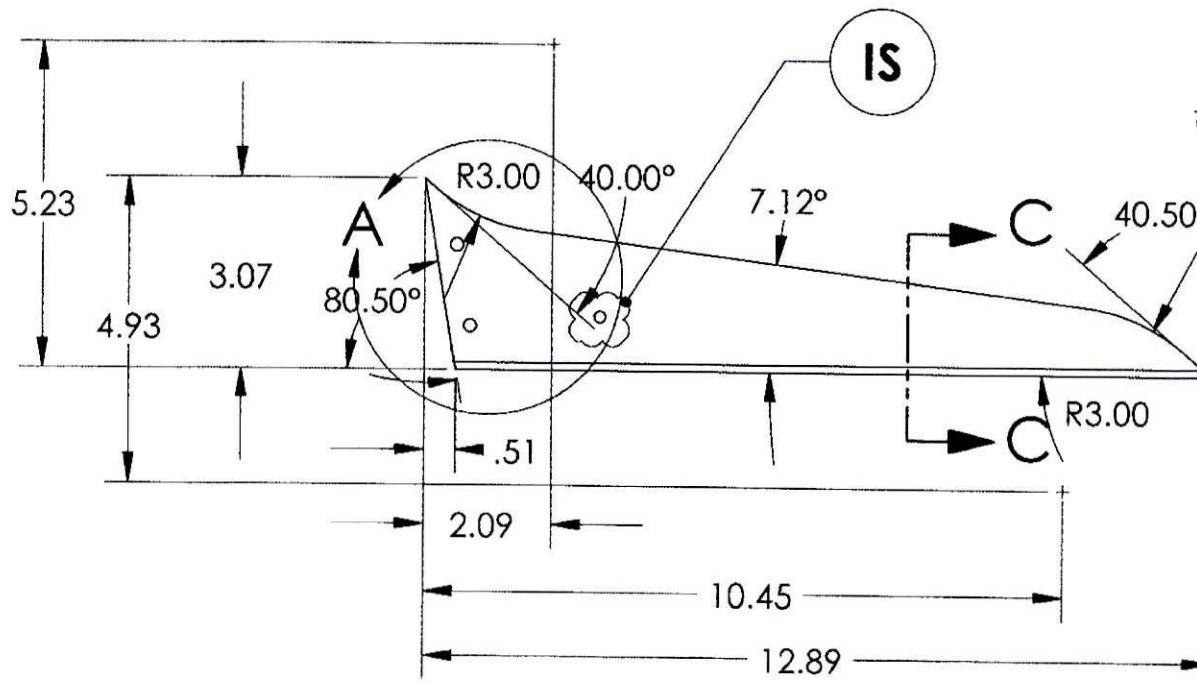
EFF. NEXT ORDER

TRANSACTION CODES (TC):
A-ADD
R-REVISE
C-CREATE
D-DELETE

REASON: ADDED HOLE DIMENSION TO 646.3313.

SHEET 5 IS:

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 150637 MLD
1608-30



DOCUMENTS EFFECTED:

☐ MDL ☐ INSTALL INSTRUCTIONS ☐ ICA ☐ FMS ☐ BOM

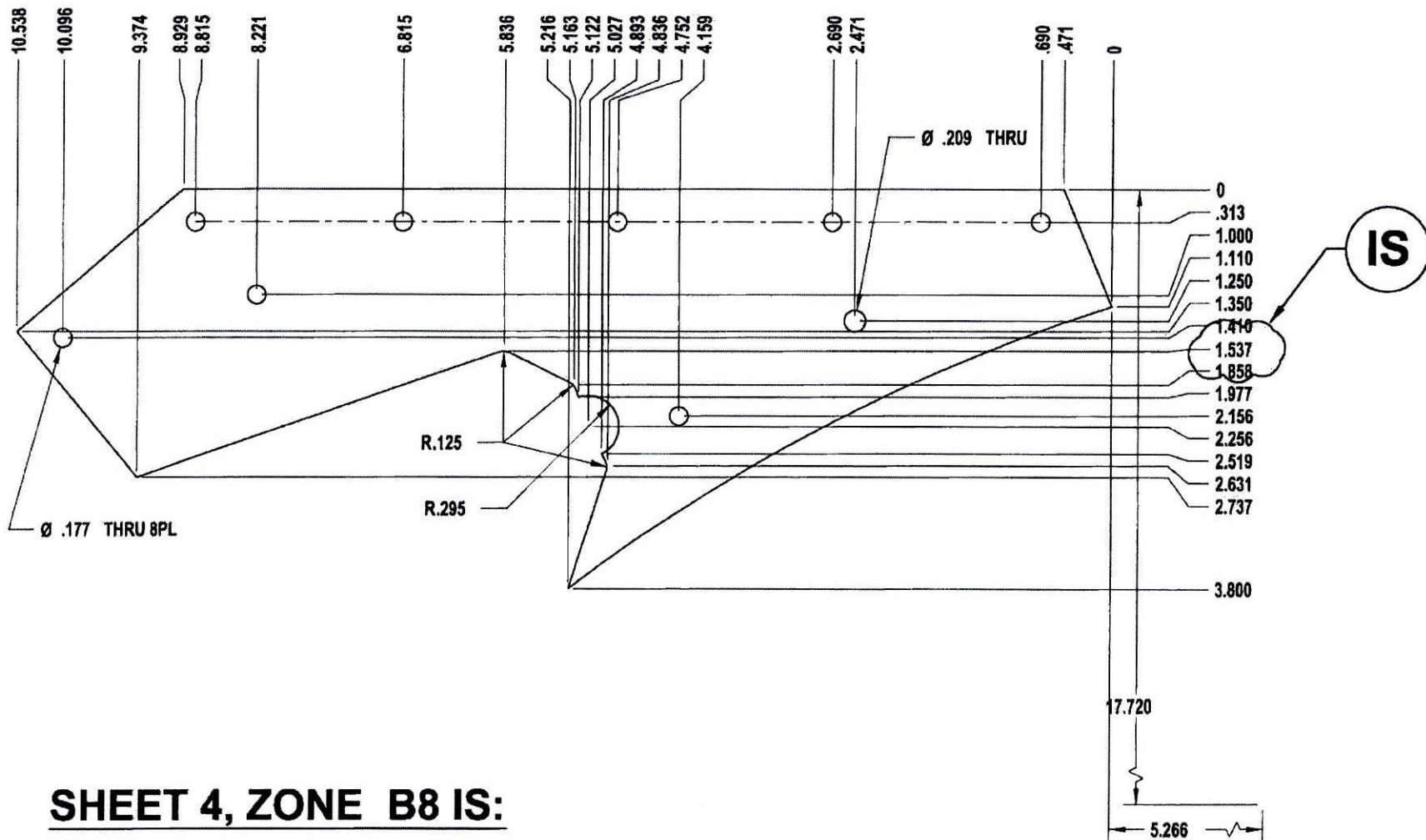
CHANGE CATEGORY

☐ MAJOR ☒ MINOR

DER REVIEW REQUIRED

☐ YES ☒ NO

APICAL INDUSTRIES, INC.	ENGINEERING CHANGE NOTICE NO. 03724				SHEET 1 OF 1	
	DWG NO. 646.3300	REV: N/C	PREPARED BY: B. PETERS	DATE: 12/05/12	EFFECT ON DWG ☐ INC. ☒ UNINC.	
	DWG TITLE: UPPER CUTTER ASSY					
	APPROVED BY: ENGR <i>[Signature]</i>	MFG <i>[Signature]</i>	QC <i>[Signature]</i>	EFF: NEXT ORDER		
TRANSACTION CODES (TC): A-ADD C-CREATE R-REVISE D-DELETE	REASON: REVISED ORDINATE DIMENSION.				ECR: D-12-025	

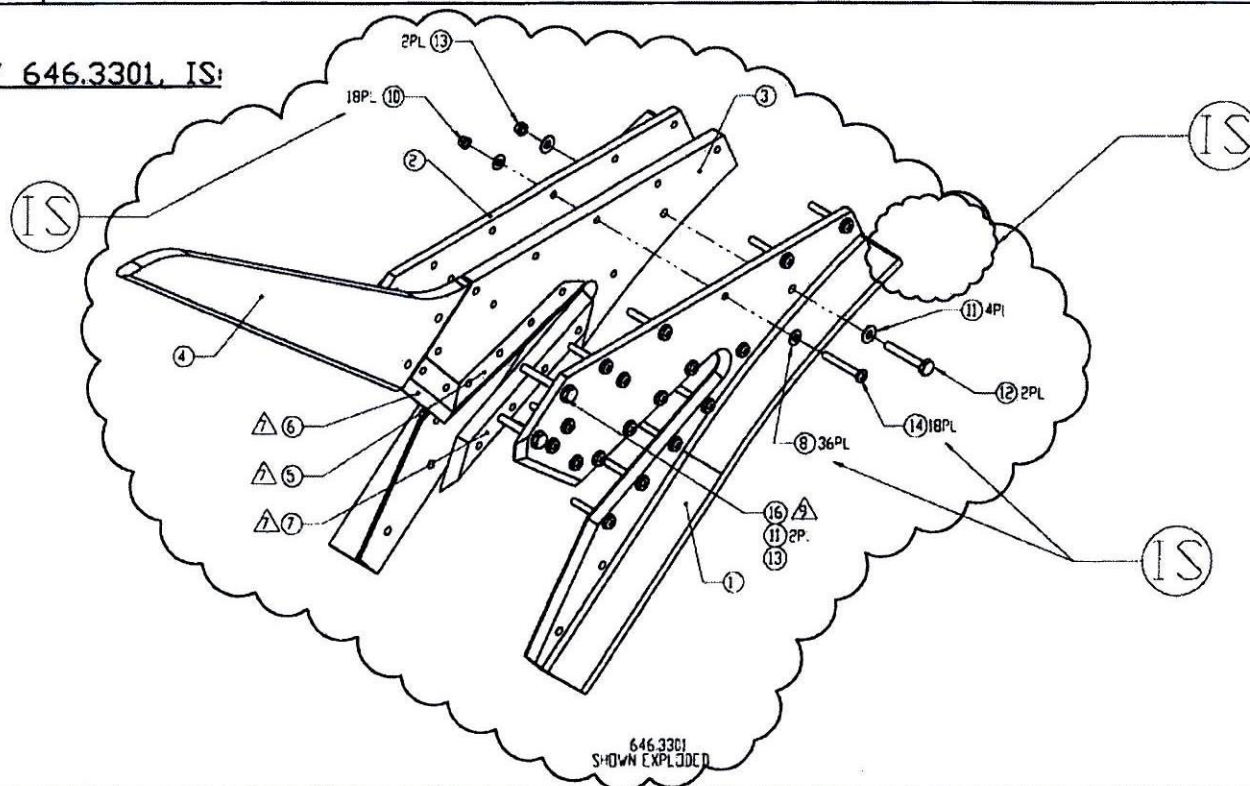


SHEET 4, ZONE B8 IS:

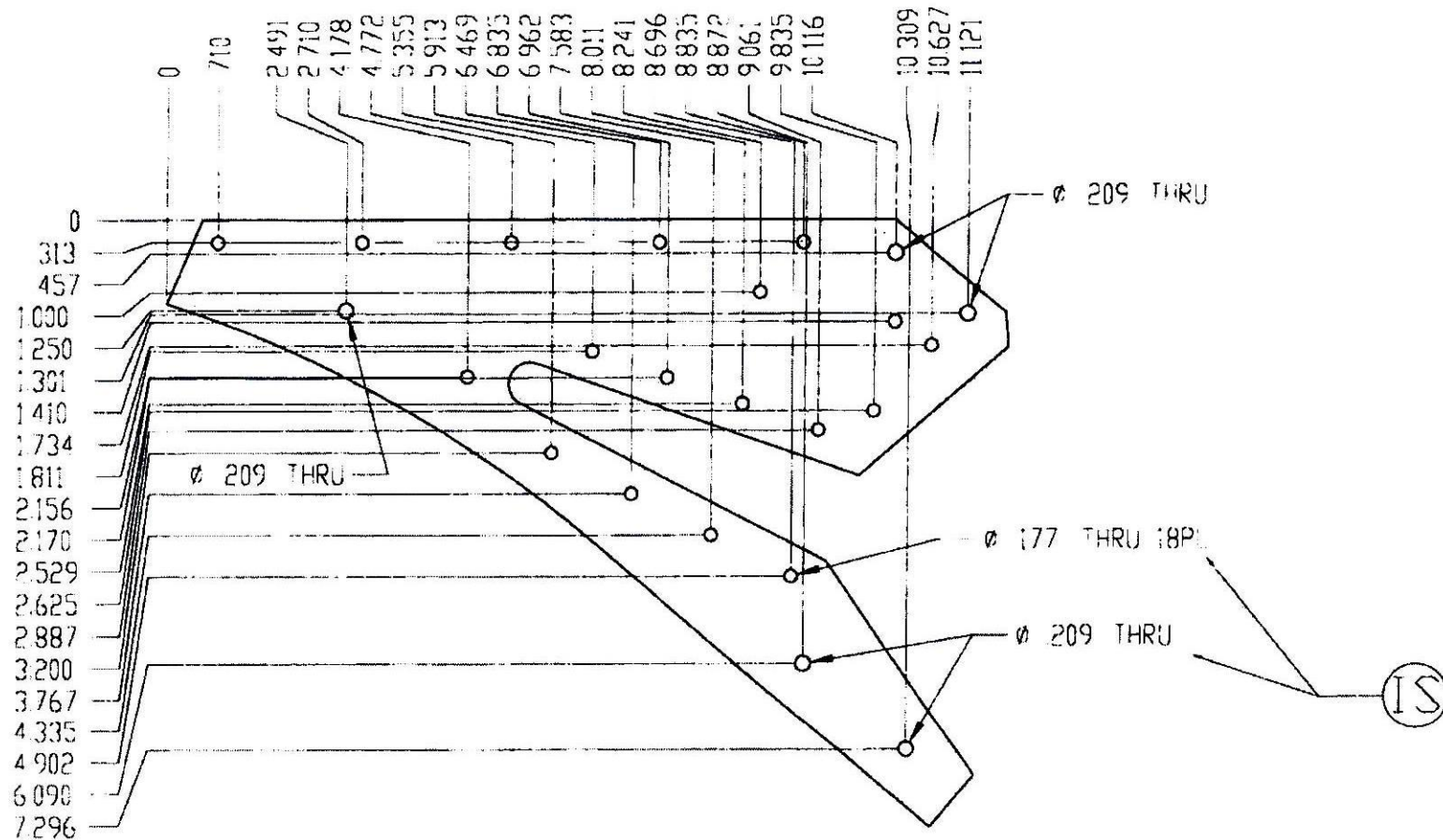
DOCUMENTS EFFECTED:	☐ RFMS ☐ MDL ☐ INSTALL INSTRU ☐ ICA ☐ BOM	CHANGE CATEGORY ☐ MAJOR ☒ MINOR	DER REVIEW REQUIRED ☐ YES ☒ NO
---------------------	--	---	--

APICAL INDUSTRIES, INC.	ENGINEERING CHANGE NOTICE NO. 02196		SHEET 1 OF 2	
	DWG NO. 646.3300	REV: N/C	PREPARED BY S. HUFF	DATE: 01/05/09
	DWG TITLE: UPPER CUTTER ASSY			
	APPROVED BY: ENGR <i>[Signature]</i>	MFG <i>[Signature]</i>	QC <i>[Signature]</i>	EFF: NEXT ORDER
TRANSACTION CODES (TC) A-ADD C-CREATE R-REVISE D-DELETE	REASON: REMOVED RIVETS IN FAVOR OF ADDITIONAL SCREWS			

SHEET 1, VIEW 646.3301, IS:



14	R	601.2765	18	SCREW	MS27039-0819
10	R	601.1541	18	LOCKNUT	MS21042L08
9	D	601.2766	3	RIVET	MS20470AD5-18
8	R	601.2764	36	WASHER	NAS1149FN832P
			3301		
F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL/SPECIFICATION
DOCUMENTS EFFECTED:				☐ MDL ☒ INSTALL INSTRU ☒ ICA ☐ FMS ☒ BOM	CHANGE CATEGORY ☐ MAJOR ☒ MINOR
				DER REVIEW REQUIRED ☐ YES ☒ NO	

SHEET 3. SECTION VIEW A-A, IS:SECTION A-A $\frac{P}{6}$

F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL/SPECIFICATION

NOTES:

- NOTES:

646.3301
SHOWN EXPLODED

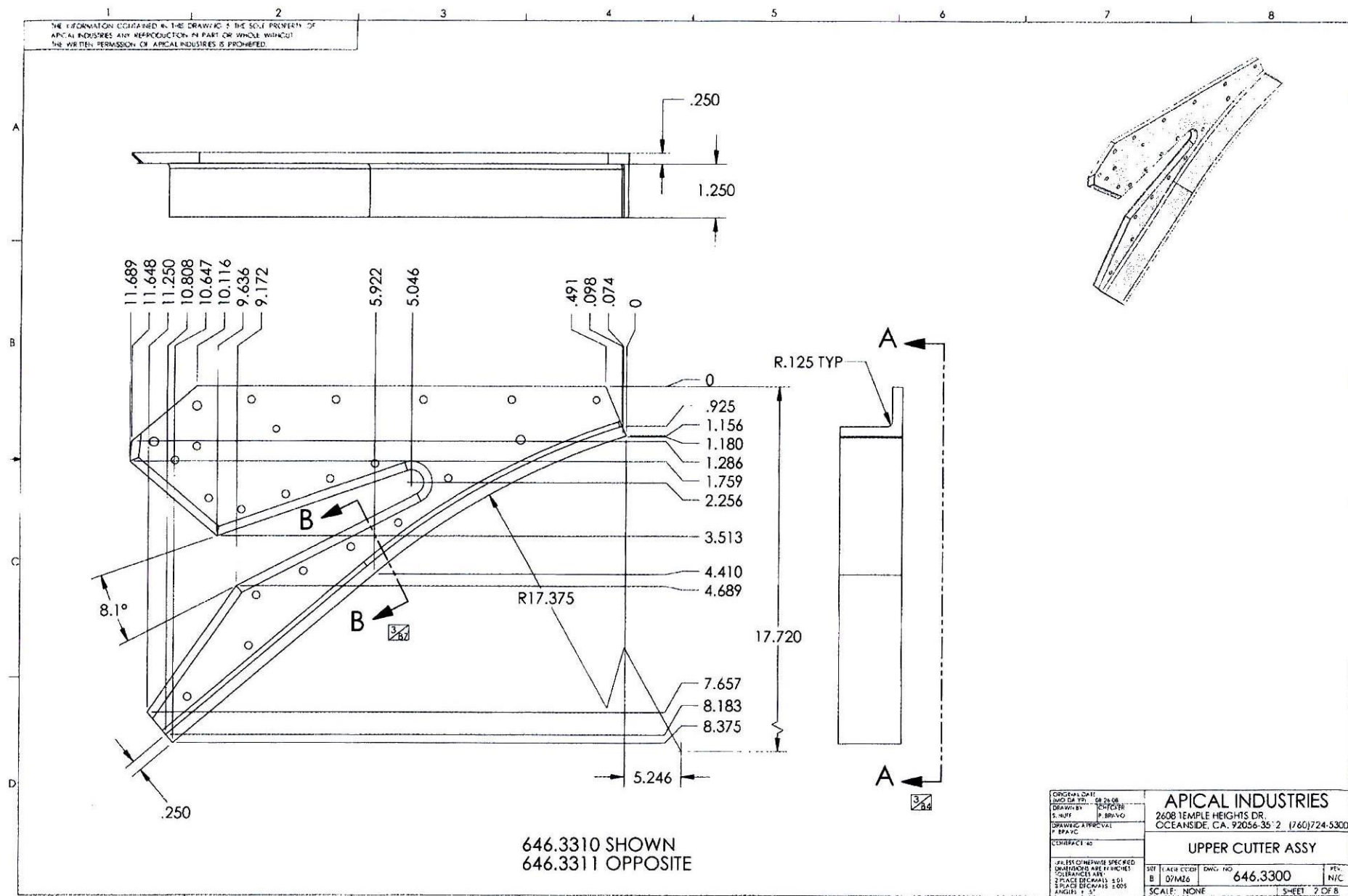
EXPENSE			
SLV	DESCRIPTION	DATE	APPROVED

UNINCORPORATED ECN(S)

02196, 03724, 04765

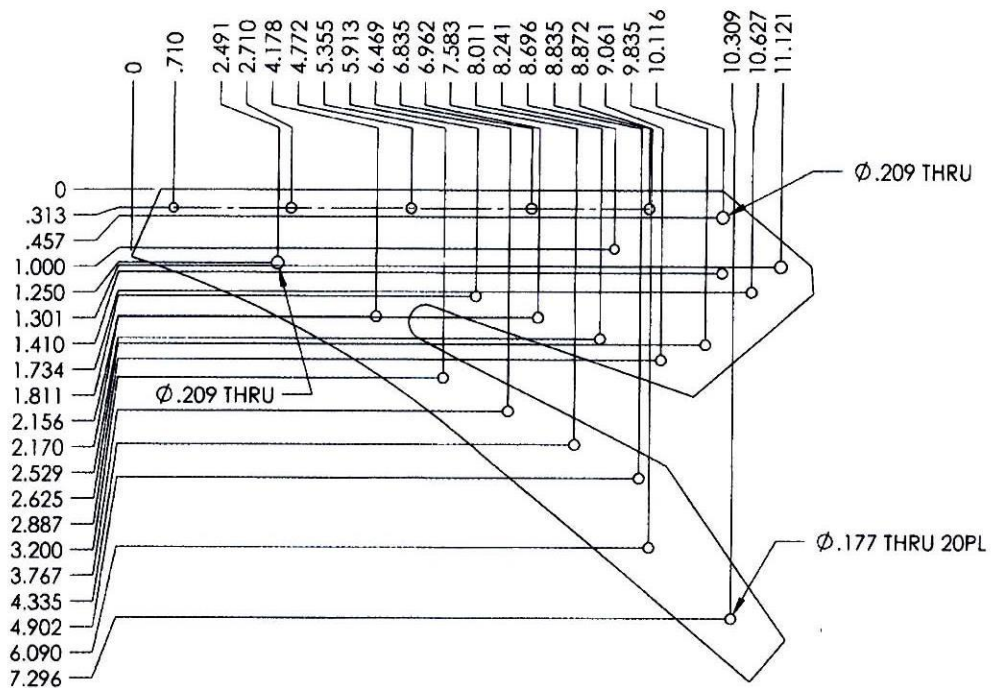
[illegible]

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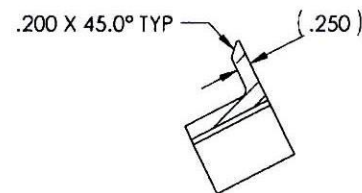


ORIGINAL DATE: 08/26/08		APICAL INDUSTRIES	
DRAWN BY: S. HUFF		2608 TEMPLE HEIGHTS DR.	
CHECKED BY: P. BRUNO		OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWING APPROVAL: P. BRUNO		UPPER CUTTER ASSY	
CONTRACT NO.		646.3300	
UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES.		SCALE: NONE	
TOLERANCES ARE:		SHEET 2 OF 8	
2 PLACE DECIMALS ±.01			
3 PLACE DECIMALS ±.005			
ANGLES ±.5°			

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SECTION A-A

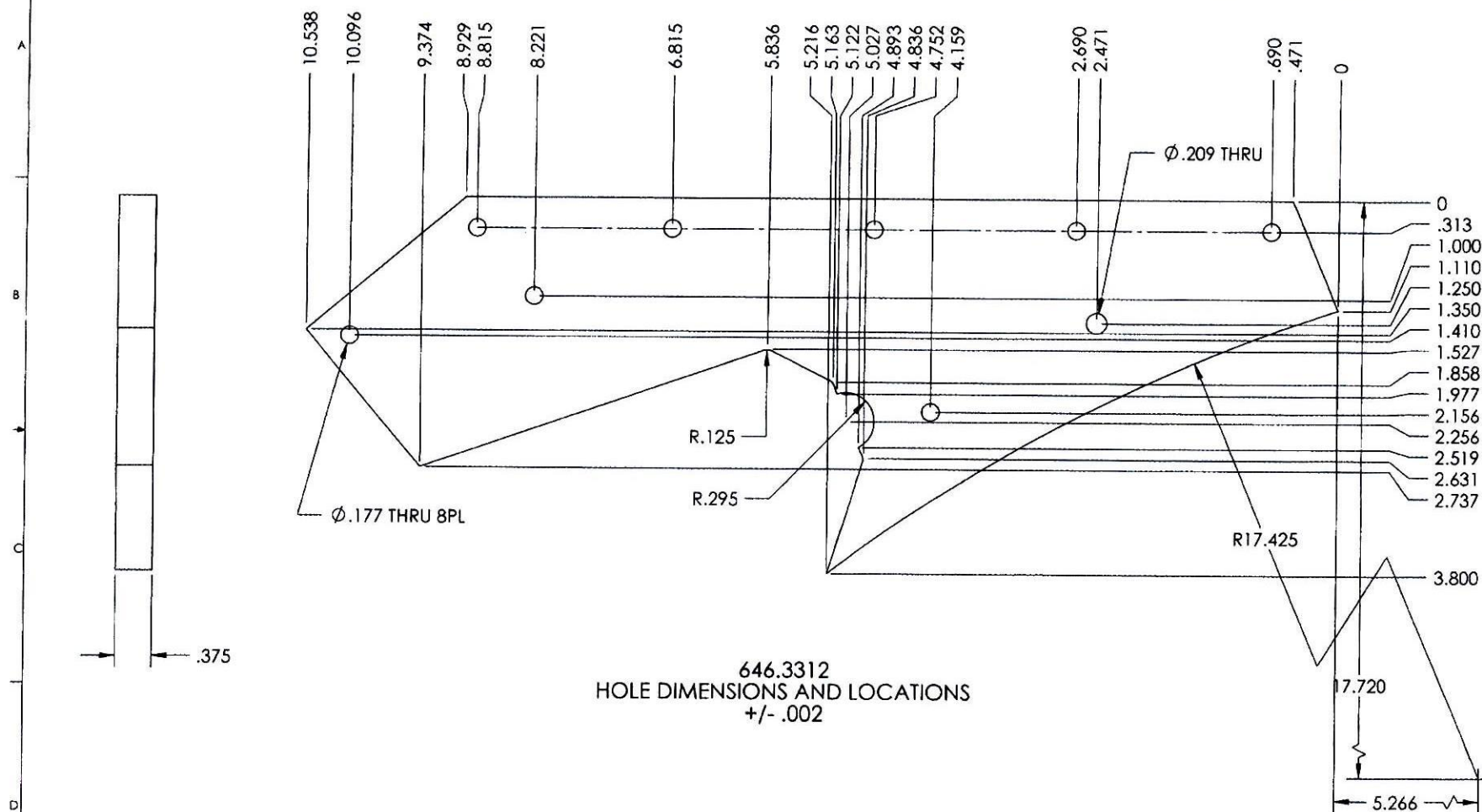


SECTION B-B

ORIGINAL DATE 10-26-00		APICAL INDUSTRIES	
DRAWN BY: C. H. C. C.		2608 TEMPLE HEIGHTS DR.	
CHECKED BY: P. B. B.		OCEANSIDE, CA. 92056 3512 (760) 724-5300	
DATE: 10-26-00		UPPER CUTTER ASSY	
CUTTER ASSY		REV. N/C	
ALL DIMENSIONS UNLESS SPECIFIED IN TOLERANCES ARE IN INCHES UNLESS OTHERWISE SPECIFIED TOLERANCES ARE: FRACTIONS DECIMALS INCHES 1/16 0.0015 0.0005 0.0001		SCALE: NONE	SHEET 3 OF 8

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THE WRITTEN PERMISSION OF APCAL INDUSTRIES IS PROHIBITED

REGIONS			
PRV	DESCRIPTION	DATE	APPROVED

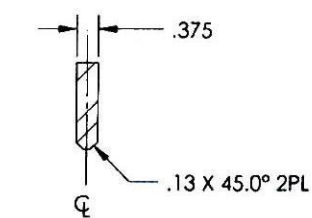
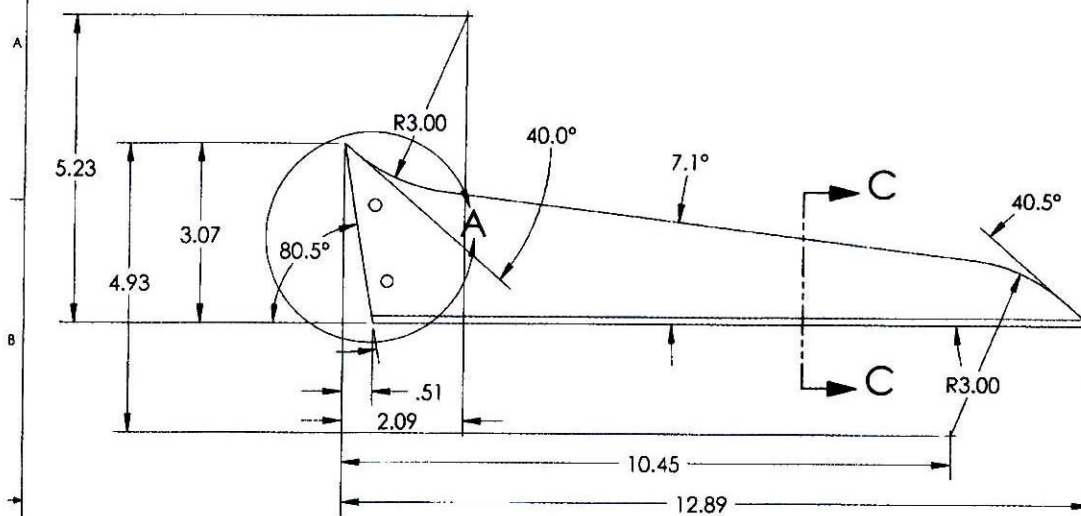


646.3312
HOLE DIMENSIONS AND LOCATIONS
+/- .002

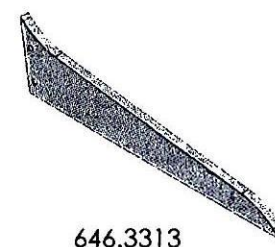
GENERAL DATE 04-20-1981 08:25 AM DRAWN BY KENCOR 1 DATE 11-81 DRAWING APPROVAL BY BEAVC SHEET CONTRACT NO.	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300 UPPER CUTTER ASSY															
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE PLACE SHOTS .01 PLACE DECIMALS .0005 AUGUST	<table border="1"> <tr> <td>SIZE</td> <td>CAGE CODE</td> <td>QTY</td> <td>NO</td> <td>REV</td> </tr> <tr> <td>B</td> <td>07M26</td> <td>646</td> <td>3300</td> <td>N/C</td> </tr> <tr> <td colspan="4">SCALE NONE</td> <td>SHEET 4 OF 8</td> </tr> </table>	SIZE	CAGE CODE	QTY	NO	REV	B	07M26	646	3300	N/C	SCALE NONE				SHEET 4 OF 8
SIZE	CAGE CODE	QTY	NO	REV												
B	07M26	646	3300	N/C												
SCALE NONE				SHEET 4 OF 8												

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APICAL INDUSTRIES AND REPRODUCTION IN PART OR WHOLE WITHOUT
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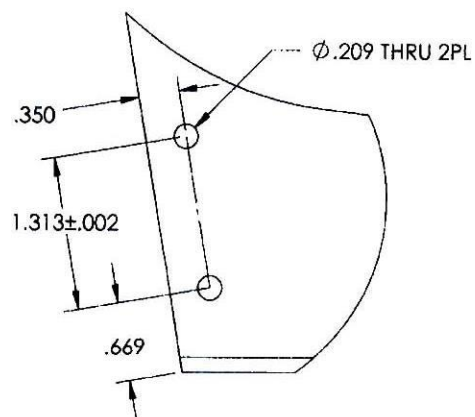
DIVISION			
RTV	DESCRIPTION	DATE	APPROVED



SECTION C-C



646.3313

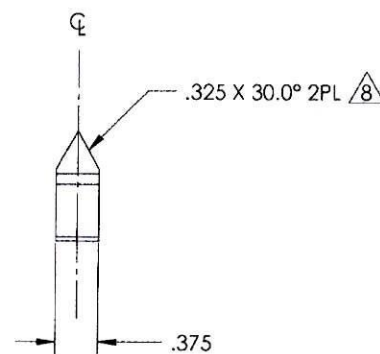
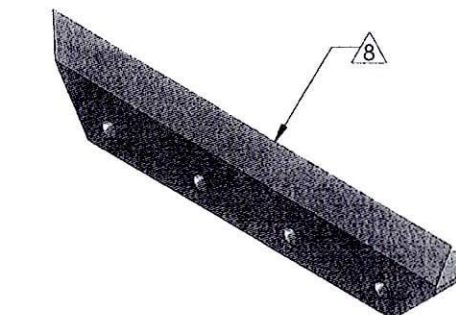
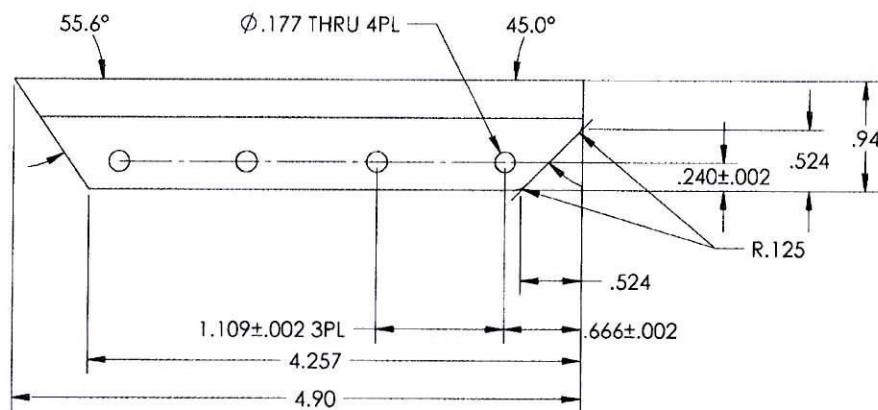


DETAIL A

ORIGINAL DATE NO DIA-108	APICAL INDUSTRIES																							
DATE WITH DIA-108	2608 TEMPLE HEIGHTS DR																							
DATE WITH DIA-108	OCEANSIDE, CA. 92056-3512 1760/724 5300																							
DATE WITH DIA-108	UPPER CUTTER ASSY																							
DATE WITH DIA-108	<table><tr><td>UNIT</td><td>CAGE CODE</td><td>QTY</td><td>NO</td><td>REV</td></tr><tr><td>SCALE</td><td>07M26</td><td>646.3300</td><td></td><td>N/C</td></tr><tr><td>SCALE</td><td>NONE</td><td></td><td></td><td></td></tr><tr><td></td><td></td><td></td><td>SHEET</td><td>5 OF 8</td></tr></table>				UNIT	CAGE CODE	QTY	NO	REV	SCALE	07M26	646.3300		N/C	SCALE	NONE							SHEET	5 OF 8
UNIT	CAGE CODE	QTY	NO	REV																				
SCALE	07M26	646.3300		N/C																				
SCALE	NONE																							
			SHEET	5 OF 8																				

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REVISIONS			
REV	DESCRIPTION	DATE	APPROVED

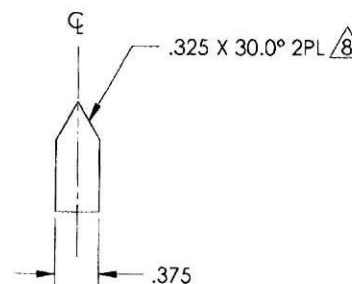
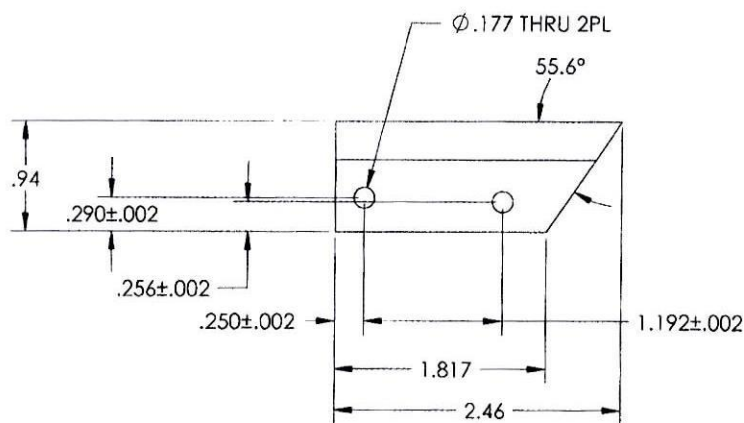
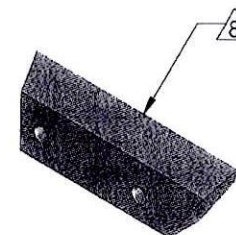


646.3314

ORIGINAL DATE 1/20/2011		APICAL INDUSTRIES	
DRAWN BY S. HUI		2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA 92056-3512 (760)724-5300	
CHECKED BY P. BLAVO		UPPER CUTTER ASSY	
DRAWING APPROVAL R. BLAVO		101 CASE CORN. DWG. NO.	REV
CONTRACT NO.		R 07M26	646.3300 N/C
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES FRACTIONS ARE 3 PLACE DECIMALS ±.01 ANGLES ±.5°		SCALE NONE	SHEET 6 OF 8

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REVISIONS			
REV	DESCRIPTION	DATE	APPROVED



646.3315

ORIGINAL DATE 1/20/08		DESIGNED BY P. BRAVO	
DRAWN BY S. HUFF		CHECKED BY P. BRAVO	
QUANTITY APPROVAL P. BRAVO			
CONTRACT NO.			
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS: .01 3 PLACE DECIMALS: .005 ANGLES: $\pm$.5°			
REV	DATE	CODE	ENG. NO.
8	07/21/26		646.3300
SCALE: NONE			SHEET 7 OF 8

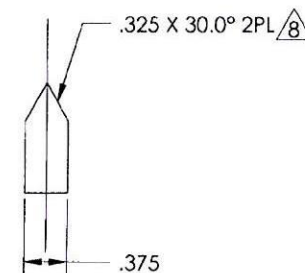
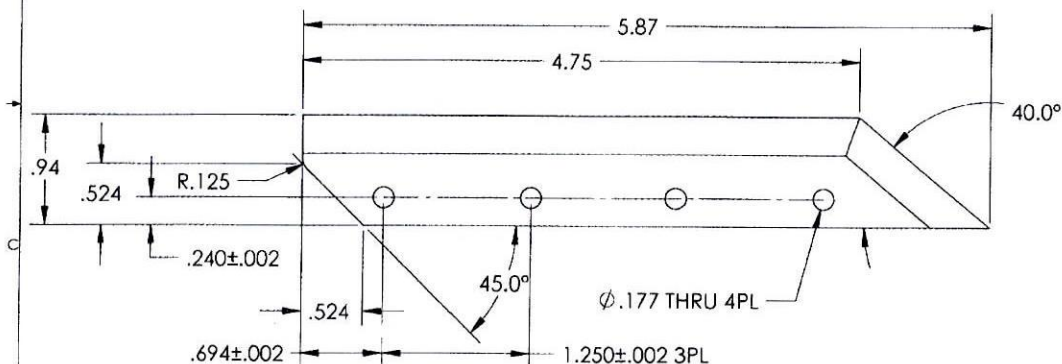
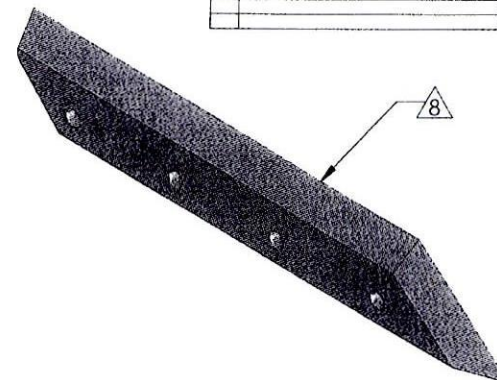
APICAL INDUSTRIES

2608 TEMPLE HEIGHTS DR.
OCEANSIDE, CA. 92056-3512 (760)724-5300

UPPER CUTTER ASSY

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REVISION			
REV	DESCRIPTION	DATE	APPROVED



646.3316

ORIGINAL DATE UNDC-CA-191 08-09-98		APICAL INDUSTRIES	
DRAWN BY S. HUNT	CHECKED P. BRAYO	2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWING APPROVAL: P. BRAYO DATE: 08-09-98 CONTRACT NO:		UPPER CUTTER ASSY	
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES TOLERANCES ARE: 1 PLACE DECIMALS ±.01 2 PLACE DECIMALS ±.005 ANGLES ±.5°		TOT. LAGE CODE B 07/M26	DATE NO 646.3300
SCALE: NONE		REV N/C	
SHEET 8 OF 8			